



W/O: 76250-1

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2893-1

PAR #:

Fault Category: Machining

NCR: Yes No

DQA:

Date: 11/11/29

Resolution: Scrap






Disposition: ~~Scrap~~QA: N/C Closed: ~~OK~~

Date: 11/11/30

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

225.78 x 2 = 451.56

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/22	100	Support gussets undercut. 4 axis parameter set wrong. P.C. operator forgot to save setting LOA	 11/23/11 PSS 042	Scrap + Daty qty x 2 (1 set) No Replace <del>mounting</del> Blanks to Redler Replaced EC 11/11/23	 11/11/23	 11/11/23	 11/23/11 PSS 042	 11/11/23

NOTE: Date &amp; initial all entries

# Work Order ID 76250

November-08-11 7:44:49 AM

**\*76250\***

Page 2

Item ID: D2893-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: 2.75 Support  
Start Date: 08/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 08/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HandFXtube	Memo	0.00				12			
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.			11-11-25					
140 <b>*140*</b> QC	QC3- Inspect Part Finish	0.00				2		11-11-28	
Quality Control	Memo	0.00							
170 <b>*170*</b> Packaging	Identify as per dwg & Stock Location: <i>X Hude</i>	0.00							
Packaging	Memo	0.00						11-11-28	

# Picklist Print

November-08-11 7:44:53 AM

Page 1

Work Order ID: 76250

**\*76250\***

Parent Item: D2893-1

**\*D2893-1\***

Parent Item Name: 2.75 Support

Start Date: 08/11/2011

Required Date: 08/12/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

11.08.04 as per dwg rev.C DD verf:EC

IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	3.0000	0.5	10.52632			
<b>*DSK078*</b>									<b>**</b>				
D2893-1 TURNING DETAIL													

## Location

MAT060

69591

70242

76060

## Loc Qty

3

1

2

## Loc Code

6

\* please pull out of system



DART AEROSPACE LTD		Work Order:	76250
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.128	.128	.128	.128	.128
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.142	.142	.142	.142	.142
AG	0.140	0.160		.148	.148	.148	.148	.148
AH	1.360	1.400		1.382	1.380	1.382	1.382	1.375
AI	0.040	0.060		.053	.053	.053	.053	.053
AJ	1.190	1.230		1.225	1.225	1.225	1.225	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.06	.06	.06	.06	.06
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.060	.060	.060	.060	.060
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>SC / SA / SA</u>	Date: <u>11/11/22</u>
Audited by: <u>BA</u>	Date: <u>11/11/24</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76250
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b> D2893-1
<b>Inspection Dwg: D2893</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.128	.128	.128	.128	.128
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.142	.142	.142	.142	.142
AG	0.140	0.160		.148	.148	.148	.148	.148
AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		.053	.053	.053	.053	.053
AJ	1.190	1.230		1.222	1.222	1.222	1.222	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.060	.060	.060	.060	.060
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.060	.060	.060	.060	.060
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> <u>SC</u>	<b>Date:</b> <u>11/11/23</u>
<b>Audited by:</b> <u>HA</u>	<b>Date:</b> <u>11/11/24</u>
<b>Prototype Approval:</b>	<b>Date:</b>

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C	08.04.21	Reformat	KJ/JLM	



DART AEROSPACE LTD		Work Order:	26250-2
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.128	.128	.128	.128	.128
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.152	.152	.152	.152	.152
AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.222	1.222	1.222	1.222	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.060	.060	.060	.060	.060
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: BC Date: 11/11/24

Audited by: b.a Date: 11/11/24

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order:	26250
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

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AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.222	1.222	1.222	1.222	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.060	.060	.060	.060	.060
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39	DS 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: BC / PA Date: 11/11/24

Audited by: LA Date: 11/11/24

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

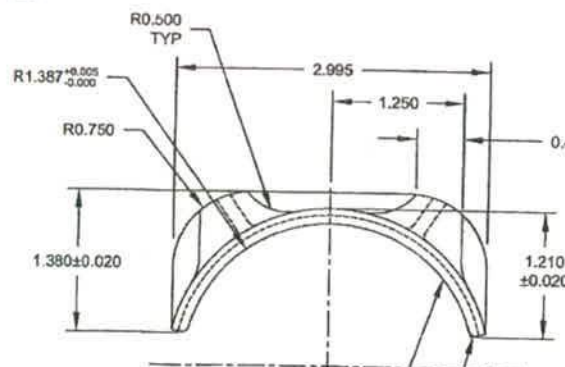
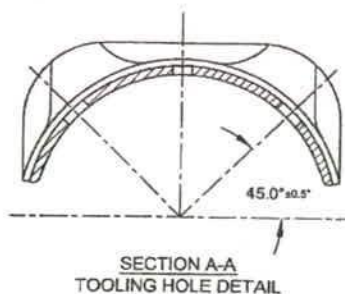
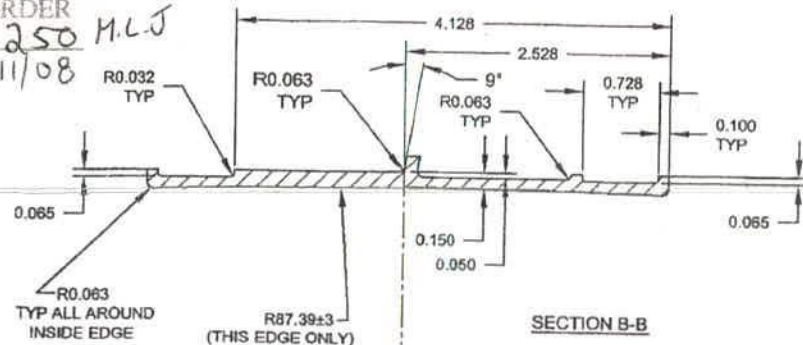
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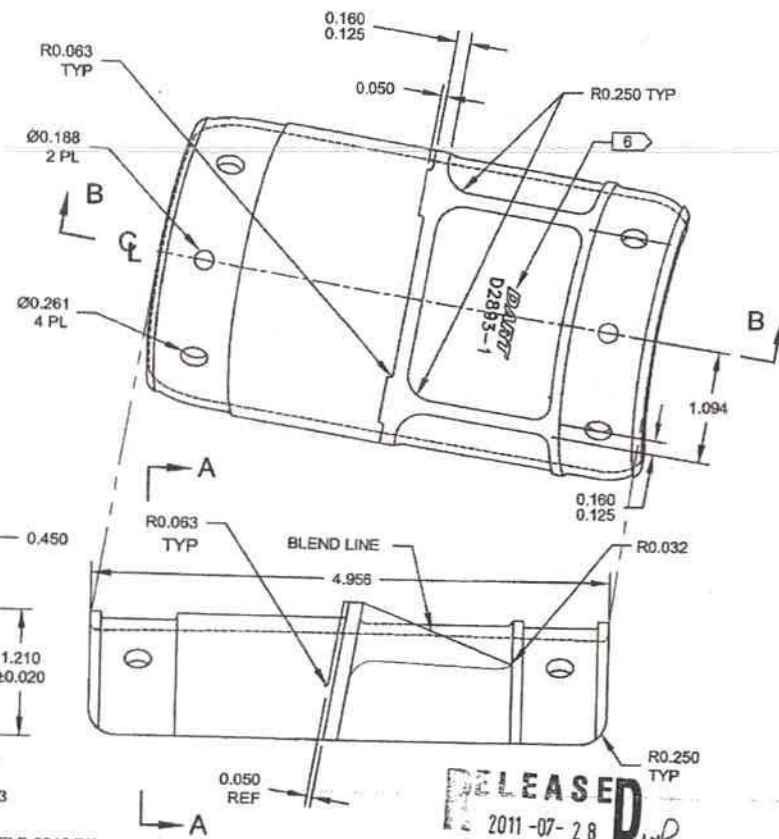
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WITHOUT NOTICE  
WORK ORDER

NO. 76250 M.L.J.  
11/11/08



D2893-1 SUPPORT



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRc)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING  
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.78 lb

- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK  
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A  
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED  
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2893  
TITLE Ø2.750 SUPPORT  
REV. C  
SHEET 1 OF 1  
SCALE NTS

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